

**PATENT CLAIMS**

1. A method for operation of a tool shaft with the aid of a sensor element of a sensor (1), in particular of an injection-molding or die-casting tool, in which the cavity (3) has at least one associated sensor (1), for example for determination of a tool internal pressure,

characterized

in that the sensor element (5) is inserted into a sleeve (4) with play (7) and is then calibrated, after determination of the sensitivity, a correspondingly codeable component, for example a resistor, is selected, is fitted in the sensor (1), and the sensor (1) is inserted with the sleeve (4) into a hole in a tool wall (2).

2. The method as claimed in claim 1, characterized in that a high-quality hole is formed in the sleeve (4), in order to hold the sensor element (5) with play (7).

3. A sensor having a sensor element (5) for determination of a parameter, in particular in the cavity (3) of an injection-molding or die-casting tool, with the sensor element (5) being arranged in a hole in a tool wall (2), characterized in that the sensor element (5) is seated in a sleeve (4) in which the sensor element (5) is guided with play (7).

4. The sensor as claimed in claim 3, characterized in that the sleeve (4) is placed on a base body (13), from which the sensor element (5) also projects.

5. The sensor as claimed in claim 4, characterized in that the sleeve (4) is screwed onto the base body (13).

6. The sensor as claimed in claim 4, characterized in that the sleeve (4) is adhesively bonded onto the base body (13).

7. The sensor as claimed in at least one of claims 3 to 6, characterized in that the sensor element (5) has an annular groove for holding a seal (12).